

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017200**Date Inspected:** 14-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Mr.Wang Jie/Liu Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

In process Inspection

**OUTSIDE YARD**

This QA Inspector observed the following work in progress:

SMAW in the 2G position for the OBG Segment 12BE, weld No: SEG3002E-237. The welders are identified as #051013. ZPMC QC is identified as Mr. Wang xiang pin. The welding variables recorded by QC appear to comply with WPS-B-P-2212-TC-U4B-FCM-1.

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 12BE, Lifting Lug at Panel Point 114 weld No: SEG3002F-233.

The welders are identified as #049339. ZPMC QC is identified as Mr. Wang xiang pin. The welding variables recorded by QC appear to comply with WPS-B-P-2214-TC-U4B-FCM-1. Please see the attached picture.

Bay #16

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 14 Bottom Plate, weld No: BP3095-001-001. The welder is

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identified as #201917. ZPMC QC is identified as Mr.Guo Pen. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2C-S-2.

This QA inspector observed the following work in progress:

FCAW welding of weld joint No: LD3031-001-054 located on OBG Segment 13AW Longitudinal Diaphragm. Welder is identified as #045280. ZPMC CWI is identified as Mr.Wang Jie. Welding was performed according to the weld repair report B-WR15038 and UT report number: B787-UT-15182.The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G(2F)-FCM-Repair. Please see the attached picture.

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Segment 13BE, weld No: KP3007-001-009. The welder is identified as #067079. ZPMC QC is identified as Mr.Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U4B-F.

This QA Inspector observed the following work in progress:

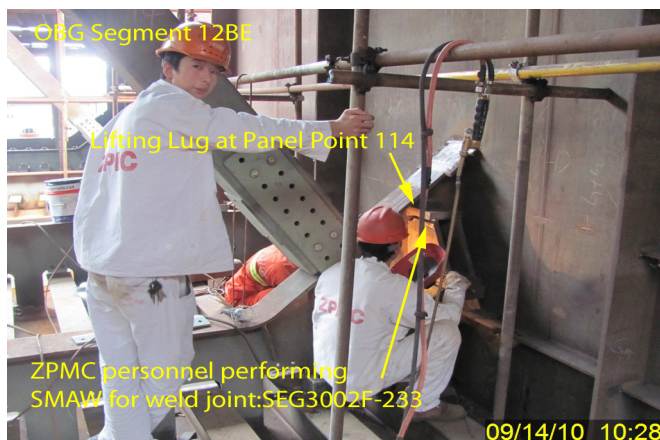
FCAW in the 2G position for the OBG Segment 13AE, weld No: KP3001-001-003. The welder is identified as #066236. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U4B-F.

Visual Inspection after Blast

Segment 11BE

This QA Inspector performed a preliminary random visual inspection after the grit blast of the Exterior components of the Deck panel, Side panels, FL3 and Bottom panel of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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### Summary of Conversations:

No Relevant Conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Pillai,Pandaram	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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